



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2438

Job Sheet 173360



Part No: D2438

Job Qty: 50 ea

Part Name: Clamp



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/28/18

Job Tracking No:

Due Date: 3/19/18

Created By: Logan David

Type: ~~Stock~~ **SOLD**

Description:

Note: DWG D2727 REV A1, D2438 REV C IPP: E 05.06.28 Bending removed KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		3/17/18	0.00	0.00	Start Up Waterjet		dc 18/03/09
100	Waterjet	50 pcs		3/17/18	0.00	1.76	Waterjet1		dc 18/03/09
120	QC	50 pcs		3/17/18	0.00	0.00	QC8		38
130	Small Fab	50 pcs		3/19/18	0.01	1.72	Small Fab		9-005
140	QC	50 pcs		3/19/18	0.00	0.00	QC5		38
150	Packaging	50 pcs		3/19/18	0.00	0.00	Packaging3	51542	MAR 23 2018
160	QC21-SA	50 Ea		3/19/18	0.00	0.00	QC21		MAR 23 2018

Part Op 100 - Cut as per dwg D2438 prog rev: C dwg rev: C

Descriptions: 120 - (6.786" center to center)

130 - 1- Use DT9713 clamp holder to hold clamp in place when forming 2- Bend as per dwg using DT9709

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	2 sf (.04 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	2	133	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	0.750inches ± 0.010	0.760 0.740		
2	Clamp	6.786inches ± 0.010	6.796 6.776		
3	Clamp	7.586inches ± 0.010	7.596 7.576		
4	Clamp	0.063inches ± 0.010	0.073 0.053		
5	Clamp	0.257inches + 0.006 - 0.001	0.263 0.256		

Plex 2/28/18 3:12 PM dart.logan.david

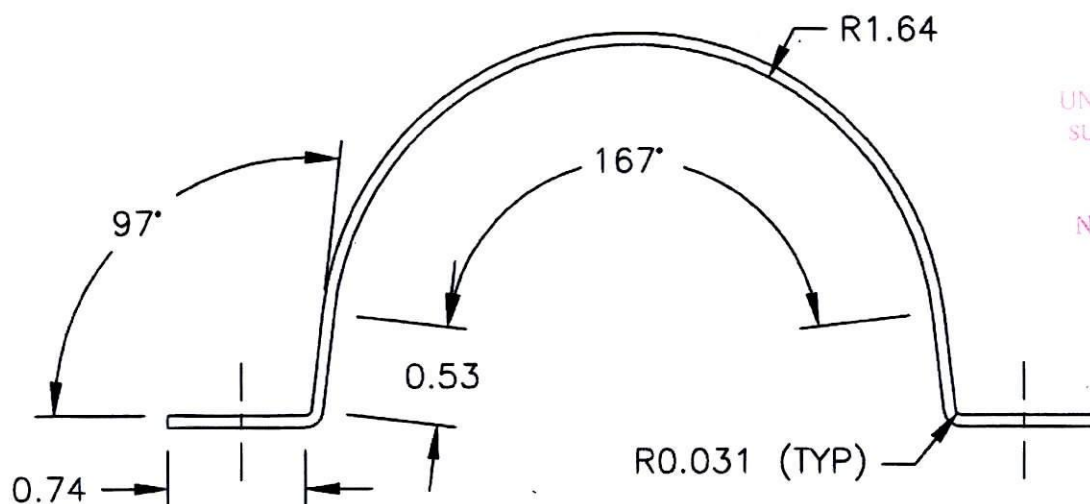
DART
AEROSPACE
Container No: S049849
Part: D2438
Job No: 173360
Serial No/Batch: S049849
Inspector:
Revision:
Date: 03/10/18

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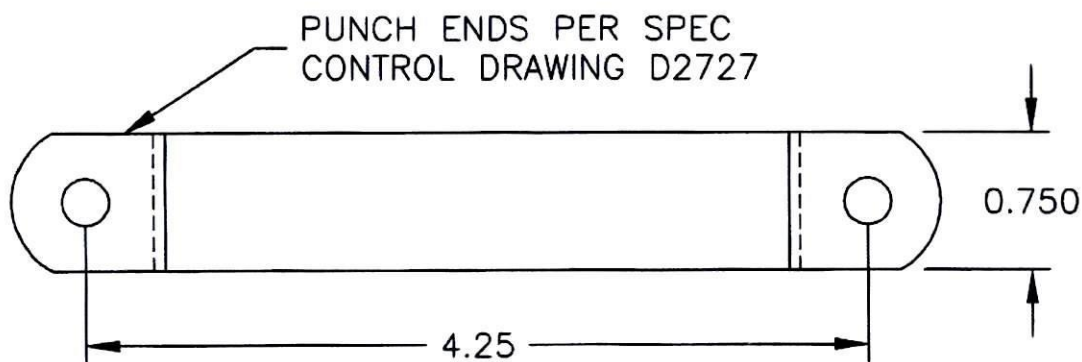
DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MD</i>	APPROVED <i>KE</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
98.06.17 KE



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WORK ORDER
NO. 173360

20180301



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK
MINIMUM REQUIREMENT IS ANNEALED CONDITION

00.06.06
CP 00.06.07